

Work Order ID 53315

October 30, 2009 9:58:00 AM



Page 1

Item ID: D212-664-107

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Low Standard Fwd

Start Date: 30/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: BP

Date: 09-10-30 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-147	Rev A								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels as per PPP D212-664-107 CHG001								
110		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging									
120		0.00							
	BENDING MACHINE - CROSSTUBES								
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D212-664-107 using CNC bender program 212-107								

Corlulig

for BG 09/11/18

Plukie SP

(IX) MB 09-11-03

Work Order ID 53315

October 30, 2009 9:58:00 AM



Page 2

Item ID: D212-664-107

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Low Standard Fwd

Start Date: 30/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

⇒ 802103

(40)

✓

140

Crosstubes

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Cut tube as per inspection dwg. ***ensure saw is square***

2-Drill pilot holes in tube as per Dwg D212-664-147

3-Drill Rivet holes as per Dwg D212-664-147 using DT8972.

4-Ream hole to finish size in tube as per Dwg D212-664-147

5-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-147

DP
9-11-4

AWM 9-11-4

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Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

1 - - AUM 9-11-4

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

278 07/10/04

(40) 6

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

278 07/10/04

(40) 6

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Item ID: D212-664-107

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Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Outsource process - NDT per QSI038 4.1	0.00							
Outsource2	Memo	0.00							
Outsource process - NDT	Liquid Penetrant Inspection as per QSI 038Or Issue P/O <u>10710</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order								
190 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect for damage & ensure results are as per Dwg D212-664-107								

09-11-5

10/11/09

11 09 11

Work Order ID 53315

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Page 5

Item ID: D212-664-107

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Revision ID: A

Item Name: Crosstube Low Standard Fwd

Start Date: 30/10/2009 Start Qty: 1.00

Required Date: 16/11/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

210

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Rivet Cuffs as per Dwg D212-664-147. with Sika flex in Between tube & Cuff
A/R SIKAFLEX -241/-291 BATCH: 112391ml 09 11 16 ①

220

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 9:30Finish Time: 10:30

PAINT:

Start Time: 3:00Finish Time: 4:30ml 09 11 16 ①

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Item ID: D212-664-107

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Low Standard Fwd

Start Date: 30/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 	QC14- Inspect Spray Paint	0.00				<u>B</u>	<u>09</u>	<u>11</u>	<u>17</u> ①
QC Quality Control	Memo Wrap in plastic bag to protect from scratches	0.00							
240 	Crosstubes	0.00				<u>ml</u>	<u>69</u>	<u>11</u>	<u>17</u> ①
Crosstubes	Memo	0.00							
Crosstubes	1- Assemble as per Dwg D212-664-147								
	2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe								
	3- Instal support with magnobond 6398 per dwg D212-664-147, cure for 12hrs before packaging.								
	Time & date of application: <u>09/11/17 11:30</u>								
	Batch: <u>112417</u>								
	EXP. DATE <u>01/2011</u>								
	Torque: <u>ml 09.11.18</u> ①								

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Item ID: D212-664-107

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Low Standard Fwd

Start Date: 30/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> Serial 18			(XL)	Ø		
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	=> Serial 19			(K)	Ø		
270 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D212-664-107	0.00 0.00	Reva			9/11/19		QSP	

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Item ID: D212-664-107**Accept****Revision ID:** A**Item Name:** Crosstube Low Standard Fwd**Start Date:** 30/10/2009 **Start Qty:** 1.00**Required Date:** 16/11/2009 **Req'd Qty:** 1.00**Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Run** **Start****Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/19 [Signature]
Pl 09-11-19
①

Picklist Print

October 30, 2009 9:58:05 AM

Page 1

Work Order ID: 53315

Parent Item: D212-664-107RevA

Parent Item Name: Crosstube Low Standard Fwd

Comments:

Start Date: 30/10/2009

Required Date: 16/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D212-664- 107TRNRevA		Manufactured	No			140	Each	6.0000	1.0000			
Crosstube Turning Detail												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
LG	6	
50700	1	
50701	1	
50705	1	
50706	1	
53113	1	
53115	1	

B-53115 MB 09-11-03

MB 09-11-03

D3659-1RevB

Manufactured No

220 Each 20.0000 2.0000

CUFF

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	15	
50691	15	
Main Warehouse		
ST477	5	
52598	5	

9-11-4

Picklist Print

October 30, 2009 9:58:05 AM

Work Order ID: 53315

Parent Item: D212-664-107RevA

Parent Item Name: Crosstube Low Standard Fwd



Comments:

Start Date: 30/10/2009

Required Date: 16/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-06 		Purchased	No			240	Each	1,706.000	44.0000			
CHERRY RIVET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1706

B11234

ml 09 11 16

107534

6

112492

200

112612

500

112724

200

112794

800

D3595-063-450RevA

Manufactured

No

240

Each

132.0278

4.0000



RUBBER CUSHION

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

127.0589474

50953

19.0589474

52447

108

ml 09 11 17

Main Warehouse

ST

4.9689

38959

2

43210

2.59

46465

0.3789

Picklist Print

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Work Order ID: 53315



Parent Item: D212-664-107RevA



Parent Item Name: Crosstube Low Standard Fwd

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25 		Purchased	No			240	Each	160.0000	4.0000			
Clamp(per MIL-DTL-8783C)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 160

107456 2

108111 3

108975 17

109181 48

109644 10

111282 4

111429 1

112495 50

112919 25

mt 09 11 17

D2893-1RevB

Manufactured No



240

Each

36.0000

2.0000



2.75 Support

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 36

25657 6

47109 10

47637 20

mt 09 11 17

Picklist Print

October 30, 2009 9:58:05 AM

Work Order ID: 53315



Parent Item: D212-664-107RevA



Parent Item Name: Crosstube Low Standard Fwd

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3428-1RevA

Manufactured

No

260

Each

21.0000

1.0000



Placard



9/11/18 SY

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST096

21

50790

21

1 k

AN6-35A

Purchased

No

260

Each

82.0000

4.0000



BOLT



9/11/18 \$

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

82

112314

62

112805

20

6x 50

AN6-36A

Purchased

No

260

Each

97.0000

4.0000



Bolt



9/11/18 50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

97

109632

1

110382

2

112314

94

6x 50

Picklist Print

October 30, 2009 9:58:05 AM

Work Order ID: 53315

Parent Item: D212-664-107RevA

Parent Item Name: Crosstube Low Standard Fwd


Comments:

Start Date: 30/10/2009

Required Date: 16/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L6  Nut		Purchased	No			260	Each	623.0000	6.0000			

9/11/18 SD

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

623

105077

22

110002

5

111548

8

111578

400

112492

188

6x

AN960JD616

Purchased

No

260

Each

798.0000

18.0000

Washer

9/11/18 SD @

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

798

112314

298

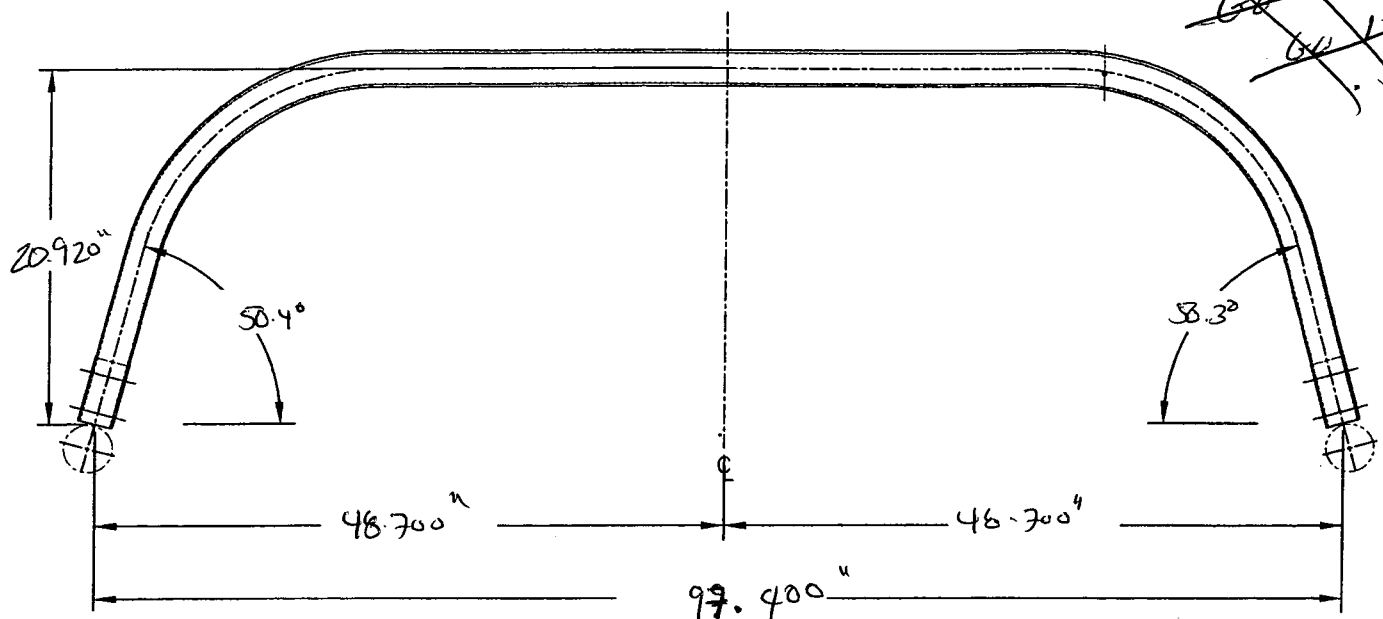
112828

500

18xSD

DART AEROSPACE LTD		Work Order: 53315
Description: Crosstube Low Fwd (205/212/412)		Part Number: D212-664-107
Inspection Dwg: D212-664-147 Rev: A		Page 1 of 1

Required Dimension	Min	Max
Height	20.79	21.05
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	<i>[Signature]</i>
Date	09/10/03

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST:

Qty	Part Number	Description
X	D212-664-147	CROSSTUBE ASSEMBLY (205/212/412 LOW FWD)
1	D6019-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
2	D3659-1	CUFF
4	MS21920-25	CLAMP (OR MS21920-26)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6019-128
FINISHED LENGTH = 126.53±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3659-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

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WORK ORDER
NO. 53315
PA 09-10-30

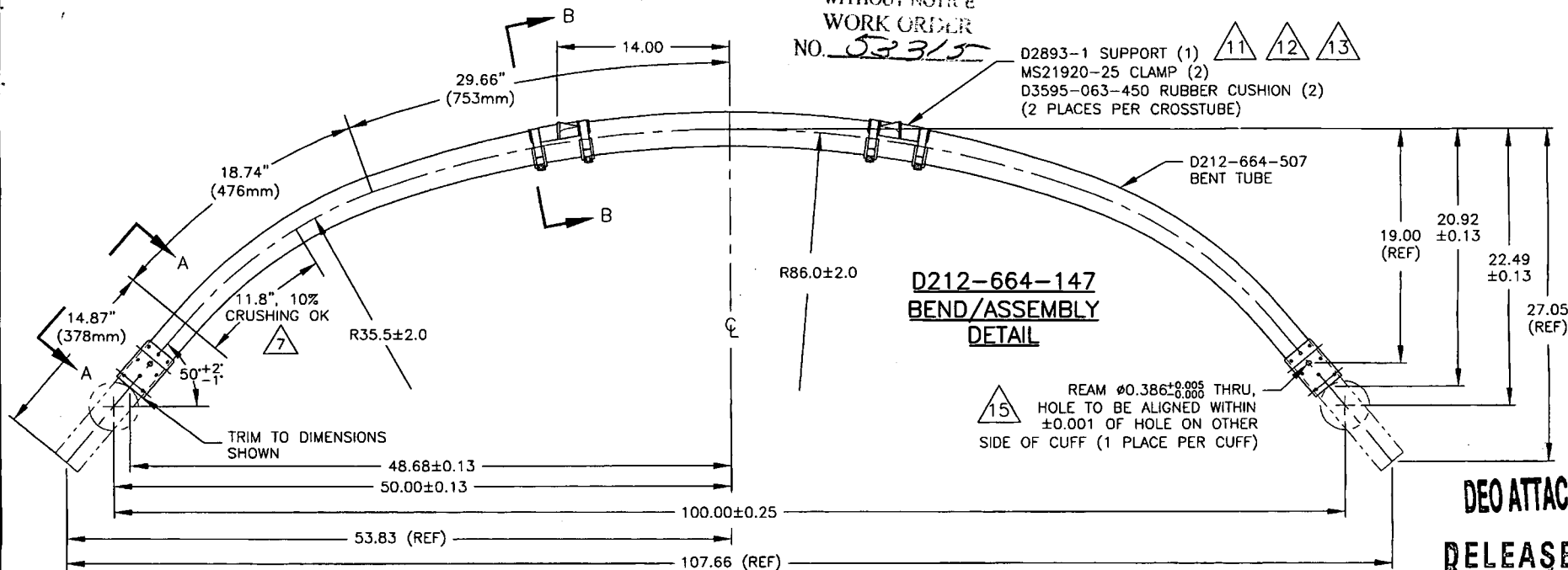
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07.09.24

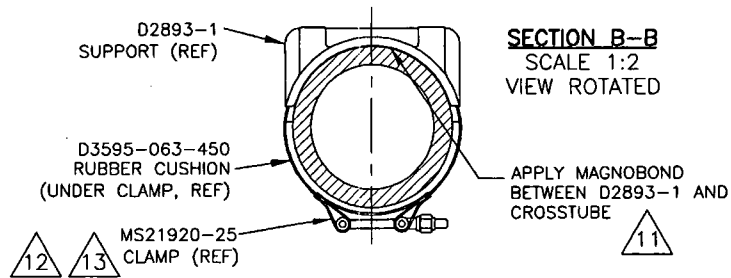
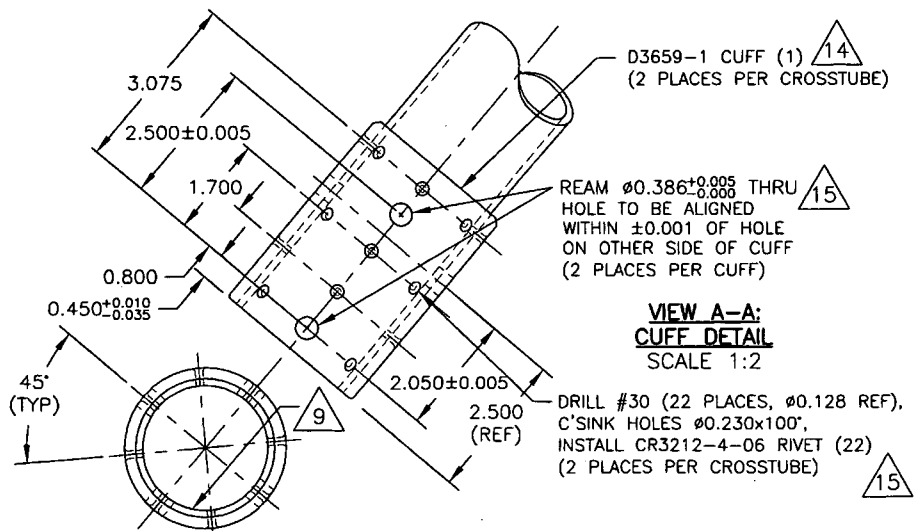
A		07.07.07	NEW ISSUE
DESIGN	<i>qp</i>	DRAWN BY	<i>qp</i>
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DATE	07.07.07	TITLE	CROSSTUBE (205/212/412 LOW FWD) NTS
		REV. A	SHEET 1 OF 3


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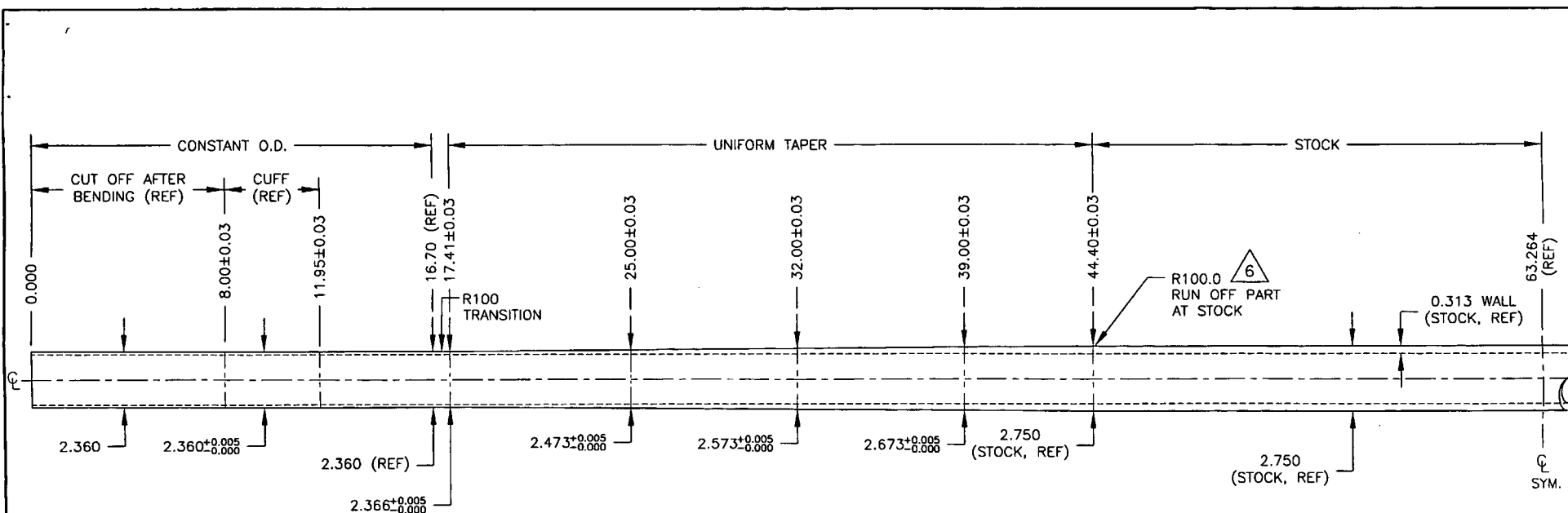
WITHOUT NOTICE
WORK ORDER
NO. 52315



DEO ATTACHED
RELEASED
07.07.07



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		DATE 07.07.07	TITLE CROSSTUBE (205/212/412 LOW FWD) 1:8		



D212-664-147 MACHINING DETAIL

RELEASED
07.07.24

DEO ATTACHED

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53315

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DATE 07.07.07		TITLE CROSSTUBE (205/212/412 LOW FWD)		SCALE 1:4	

DRAWING NO. D212-664-147	TITLE CROSSTUBE	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-147-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>U</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>PH</i>		
DATE 09.05.01	DATE 09.06.15	DATE 09.06.15	DATE 09/06/16		DATE 09/06/16		

CHANGE:

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D212-664-147B	CROSSTUBE ASSEMBLY (214 LOW FWD)

THE D212-664-147B CROSSTUBE HAS THE SAME PARTS LIST AS THE D212-664-147 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D212-664-147 CROSSTUBE.

RELEASED
09/06/22 *MD*

SHOWN
REVISION
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53315

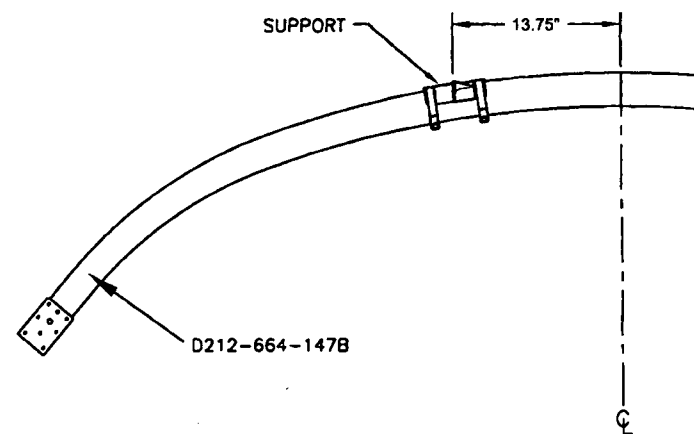


FIGURE 1 - SUPPORT INSTALLATION

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[illegible]